

Date: Wednesday, 04/10/2006 2:11:43 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 28873
 Estimate Number : 12175
 P.O. Number : N/A
 This Issue : 04/10/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : 27024
 Written By : U
 Checked & Approved By : U
 Comment : Est Rev:A New Issue 06-02-03 JLM

Drawing Name : DUCT
 Part Number : D34761
 Drawing Number : D3476 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 11/10/2006

Qty: 42 Um: Each

Additional Product

1 ASAP

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 0.4374 sf(s)/Unit Total : 1.7497 sf(s)

see p. 2 304/316 0.018 SHEET

Batch: M100843

11102376 M 06 10 16

M 06 10 13

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

Cut as per Dwg D3476

Dwg Rev: A

Prog Rev: A

M 06 10 16

M 06 10 13

(4)

(4)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 06 10 16

M 06 10 13

(4)

(4)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

M 06 10 13

M 06 10 13

(4)

(P7C)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

2-Roll as per Dwg D3476

3-Spot weld as per Dwg D3476 and Dart QSI 018

M.F. 06/10/13

M.F. 06/10/13

(2)

(1)

(P7C)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3476-1 PAR #: N/C Fault Category: Prod/Eng. Ass^y ^{med & small} NCR: Yes No DQA: LP Date: 06/11/03
 QA: N/C Closed: AS Date: 06.11.03

NCR: <u>28873</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-10-16	2.0	2 parts made with 22 ga, To replace the 26 ga, cause there was none in stock. Dwg was Eng. approved by hazel change.	<u>AS</u> <u>06/10/16</u>	Parts unacceptable. to not fit. scrap & destroy. Replace with .018" mat'l.	<u>ML</u> <u>06/10/16</u>	<u>AS</u> <u>06-10-16</u>	<u>AS</u>	<u>06-10-16</u>
06-10-17	2.0	4 new Received .018 ss.	<u>AS</u> <u>06/10/16</u>	4 new parts made with .018" mat'l, AS required.	<u>ML</u> <u>06/10/16</u>	<u>AS</u> <u>06-10-16</u>	<u>AS</u>	<u>06-10-16</u>
06-10-17	5.0	2 parts spot welded i did not fit. B. M. Adapter And Motor casing where not exactly the same size, casing A terrible fit.	<u>AS</u> <u>06/10/16</u> <u>Dan</u> <u>06/10/17</u>	1 part for next ass'y. 1 part scrapped & destroyed.	<u>Matthew</u> <u>06/10/17</u>	<u>AS</u> <u>06/10/17</u>	<u>AS</u>	<u>06-11-02</u>

NOTE: Date & initial all entries

Date: Wednesday, 04/10/2006 2:11:44 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUCT

Job Number: 28873

Part Number: D34761

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5/11

INSPECT WORK/INSPECT SPOT WELD



Comment: INSPECT WORK/INSPECT SPOT WELD

06-10-17

③

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location *GA*

SB 06/11/1

③

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/03

③

Job Completion



U 06-11-02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

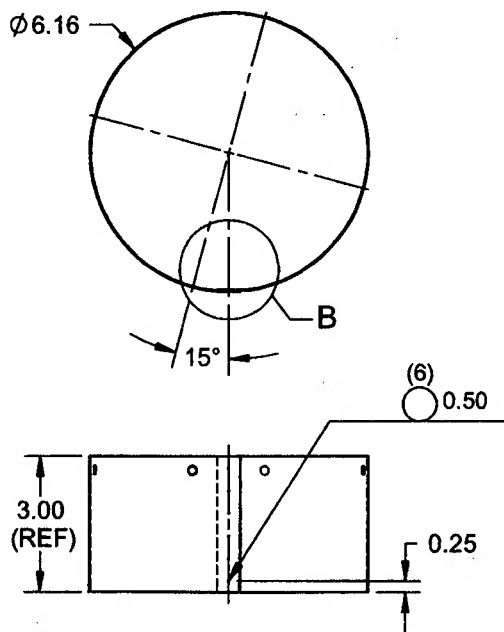
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

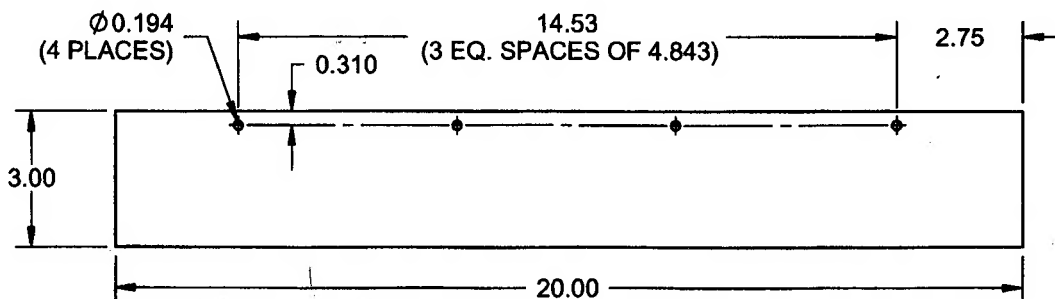
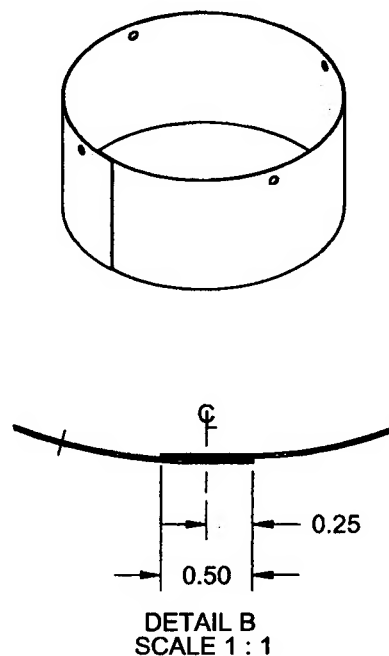


DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3476	REV. A SHEET 3 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:4

H 06.04.03



D3476-1 DUCT



D3476-1F DUCT FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

22
FOR 1
PART ONLY
06.10.13

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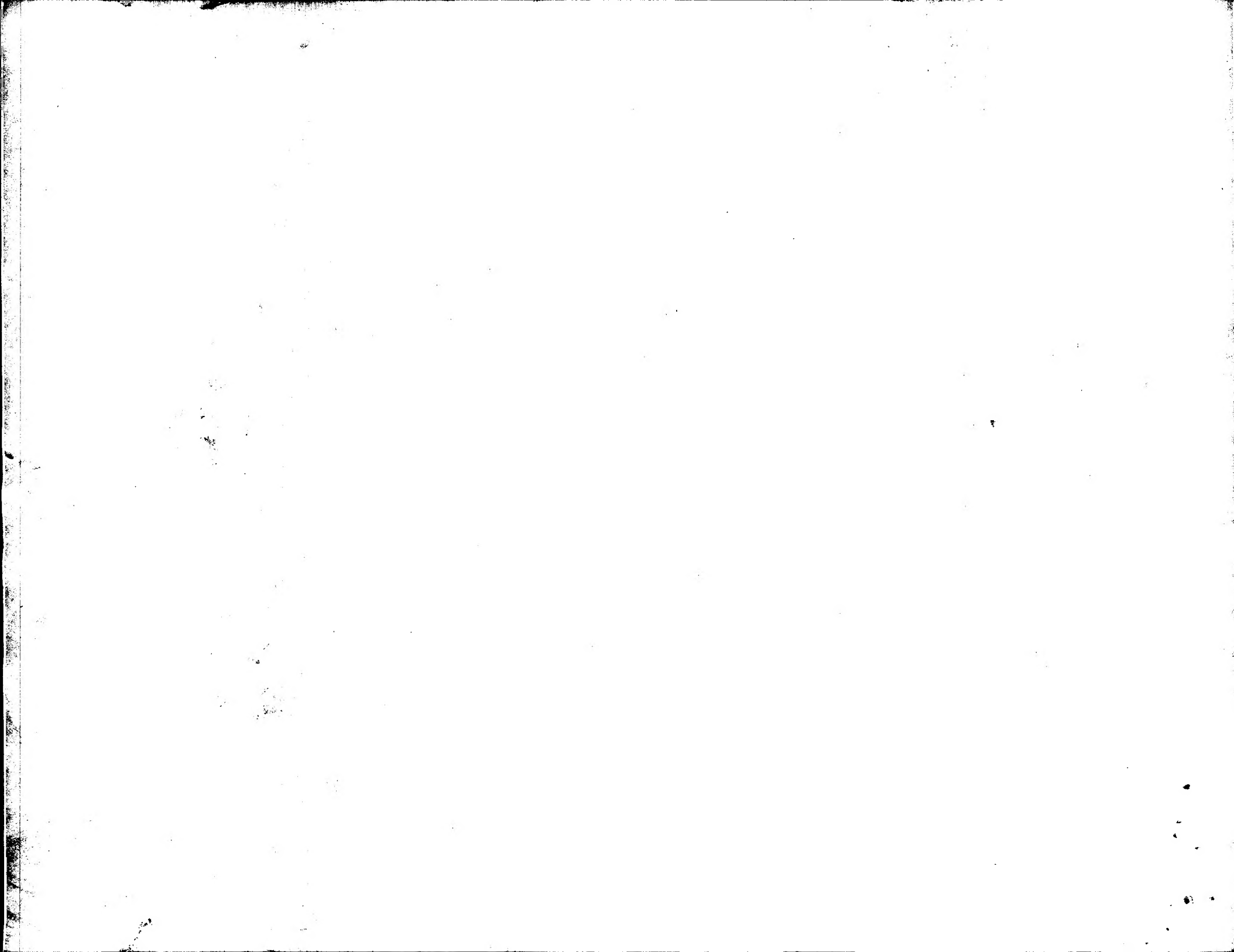
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



NO. 37

AMS-W-6858A

~~AWS D17.1.2001~~

QUALIFICATION TEST RECORD

Name Helanie FanteuxJoint Welding Procedure SpotweldingPart number and Job number D3476-1 B28873 / D3476-043 B28565

TEST WELDS REQUIRED.

BASE METAL SS.WELDING PROCESS SpotweldPenetration Complete ☐ Partial ☐Single Weld ☐ Double Weld ☐Current AC ☐ DC ☒Backing YES ☐ NO ☐

	Position		Vertical Down <input type="checkbox"/> Up <input type="checkbox"/>	
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into

Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐Penetration Pass ☒ Fail ☐Crossbolt Spacer Pass ☐ Fail ☐

AMS-W-6858A

The above named individual is qualified in accordance with ~~AWS D17.1.2001~~ to weldDate of Test Coupon 06.10.17Qualifier Jean Muth